

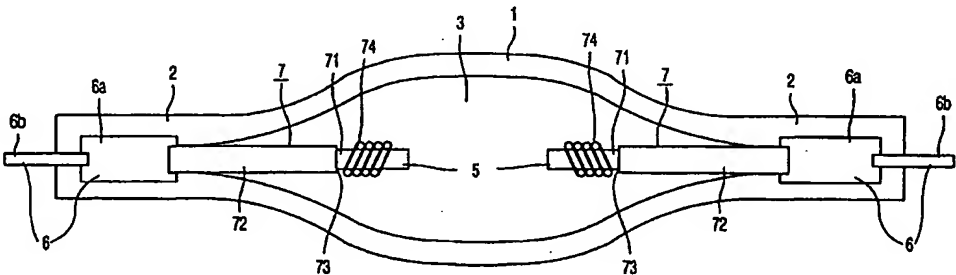
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<p>(21) International Application Number: PCT/IB98/00195 (22) International Filing Date: 16 February 1998 (16.02.98) (30) Priority Data: 97200507.8 24 February 1997 (24.02.97) EP (34) Countries for which the regional or international application was filed: NL et al. (71) Applicant (for all designated States except US): KONINKLIJKE PHILIPS ELECTRONICS N.V. [NL/NL]; Groenewoudseweg 1, NL-5621 BA Eindhoven (NL). (71) Applicant (for SE only): PHILIPS NORDEN AB [SE/SE]; Kottbygatan 7, Kista, S-164 85 Stockholm (SE). (71) Applicant (for DE only): PHILIPS PATENTVERWALTUNG GMBH [DE/DE]; Röntgenstrasse 24, D-22335 Hamburg (DE). (72) Inventors; and (75) Inventors/Applicants (for US only): KUBON, Marcus [DE/DE]; Prof. Holstlaan 6, NL-5656 AA Eindhoven (NL). SCHOLL, Robert, Peter [DE/DE]; Prof. Holstlaan 6, NL-5656 AA Eindhoven (NL).</p>		<p>(74) Agent: EVERS, Johannes, H., M.; Internationaal Octrooibureau B.V., P.O. Box 220, NL-5600 AE Eindhoven (NL). (81) Designated States: CN, JP, US, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</p>
<p>(54) Title: A HIGH-PRESSURE METAL HALIDE LAMP</p>  <p>(57) Abstract</p> <p>A high-pressure metal halide discharge lamp has opposite tungsten electrodes (5) carried by electrode rods (7). These rods (7) have a first portion (71) of tungsten adjacent the electrodes (5) and a second portion (72) made of at least 25 % by weight of rhenium. Their common boundaries are at a location having during operation a temperature in the range of 1900 - 2100 K. The gas filling contains metal oxyhalide and is devoid of rare earth metal compounds. The lamp has a long life and a high luminous maintenance.</p>		

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A high-pressure metal halide lamp

The invention relates to a high-pressure metal halide lamp comprising:
a sealed light-transmittent discharge vessel having opposite seals and
enveloping a discharge space which has a gas filling comprising rare gas and metal halides;
5 tungsten electrodes oppositely disposed in the discharge space;
current lead-through conductors located in a respective seal of the
discharge vessel and issuing from the discharge vessel;
electrode rods connected to a respective one of said lead-through
conductors and carrying a respective one of said electrodes.

10

Such a lamp is known from US-A-5,424,609.

The known lamp has a ceramic discharge vessel, current lead-through
conductors of e.g. niobium or tantalum, and a gas filling of rare gas, mercury and a mixture
15 of metal iodides including rare earth metal iodides, being the iodides of the lanthanide's,
scandium and yttrium, as the metal halides.

In ceramic discharge lamps the current lead-through conductors generally
extend into the discharge space, thereby being exposed to attack by the metal halides. In the
known lamp the inner ends of the current lead-through conductors are embedded in ceramic
20 sealing material of the seals and a respective conductor which is said to be halide-resistant at
least as its surface issues from the seals and connects the lead-through conductors with
tungsten electrode rods. The said conductors at least at their surface consist of tungsten,
molybdenum, platinum, iridium, rhenium, rhodium, or an electrically conducting silicide,
carbide or nitride.

25 It was found that the known lamp suffers from a decreasing luminous
output due to a blackening of the discharge vessel which is caused by the deposition of
tungsten originating from the electrodes and the electrode rods.

A single ended quartz glass metal halide lamp is known from EP-A
0.343.625 in which the gas filling consist of rare gas, mercury and a mixture of metal

iodides and metal bromides. Both lead-through conductors are embedded next to one another in the one seal of the discharge vessel and the electrode rods extend next to one another into the discharge space. Due to the elevated temperature of the electrode rods during operation and their short mutual distance, in such a lamp the discharge arc may jump over from the electrodes to the electrode rods, thereby approaching the discharge vessel and causing it to become overheated. The jump over of the discharge arc, however, also causes the electrode rods to become even more heated, to evaporate locally and thereby to blacken the discharge vessel and to become broken themselves. Moreover, the short distance in the kind of lamp between the electrode rods and the portion of the discharge vessel which is heated to softening in making the seal during manufacturing the lamp, causes tungsten electrode rods to become oxidized, which results in a fast blackening of the discharge vessel during operation.

In the lamp of EP-A 0.343.625 oxidation of the electrode rods and a jump over of the discharge arc are obviated in that the electrode rods at least at their surface consist of rhenium or rhenium-tungsten alloy. These electrode rods project through a tungsten electrode coil at their ends inside the discharge space. Rhenium is less liable to become oxidized and has a lower heat conductivity, whereby a rhenium electrode rod would assume a lower temperature during operation. Preference is given to rhenium-tungsten alloys containing 3 to 33 % by weight of rhenium, because rhenium is an expensive metal. It was found, however, that the lamp has the severe disadvantage to suffer from a rapid blackening due to evaporation of rhenium and deposition of rhenium on the discharge vessel.

A similar single ended quartz glass lamp and a double ended quartz glass lamp are known from US-A-5,510,675. These lamps have a gas filling of rare gas, mercury and a mixture of metal iodides and bromides. Their electrode rods have at their end inside the discharge space a wrap winding of tungsten wire and a fused spherically shaped tungsten electrode head. The purpose thereof is to eliminate flicker which is caused by migration of the discharge arc. The electrode rods may consist of rhenium in stead of tungsten. It was found that the lamp having rhenium electrode rods suffers from a rapid blackening due to evaporation of rhenium and deposition of rhenium on the discharge vessel.

In the event the electrode rods consist of tungsten, blackening of the discharge vessel may occur as a result of evaporation of tungsten from the electrode rods and the electrodes, and deposition on the discharge vessel. Moreover in this event, the electrode rods may locally become thinner and thinner, resulting in the breakage of the rods at a relatively early moment.

It is an object of the invention to provide a high-pressure metal halide lamp of the kind described in the opening paragraph in which blackening of the discharge vessel and breakage of the electrode rods are obviated.

5 This object is achieved in the lamp of the invention in that the gas filling contains metal oxyhalide and is substantially devoid of rare earth metal compounds, the electrode rods have a first portion of tungsten adjacent the electrode which merges into a second portion at a location having a temperature in the range of 1900 - 2300 K during operation, the second portion is made of at least 25 % by weight of rhenium, rest tungsten
10 and being secured to a respective current lead-through conductor.

The invention is based on an insight having several aspects.

The discharge vessel may be kept clear by a fast acting regenerative cycle, by which evaporated tungsten is transported to the electrodes as tungsten oxyhalide, e.g. oxybromide. Tungsten oxyhalide decomposes near the electrodes and tungsten is
15 deposited on the electrodes. Free halogen, e.g. bromine or iodine, and oxygen in the gas atmosphere of the operated lamp are essential to achieve a fast transport. Rare earth metals have a high affinity to oxygen, which results in stable oxides and excludes the existence of free oxygen in the gas atmosphere. Therefore, rare earth metals must be substantially absent.

Rhenium has a vapor pressure which increases rather steeply at
20 increasing temperature. Rhenium cannot be returned to the electrode rods by means of halogen, because rhenium does not react with halogen or with halogen and oxygen. Rhenium must be avoided at locations having a relatively high temperature during operation.

Halogen, particularly bromine, and oxygen together form effective means to transport tungsten from locations of relatively low temperature, such as from the wall of
25 the discharge vessel, to the electrode. However, the electrode rods, too, have locations of a temperature at which tungsten reacts with oxygen and halogen to form volatile compounds. The presence of oxygen and halogen in the gas atmosphere of an operating lamp, causes the electrode rods to become locally thinner until breakage occurs.

When the second portion is made of a tungsten/rhenium mixture, an
30 amount of at least 25 % by weight of rhenium in the mixture is necessary. When the tungsten is removed from the mixture by reaction with the halogen, a remainder of the second portion substantially consists of rhenium. Only when at least 25 % by weight of rhenium is initially present in the mixture, the remainder of the second portion is strong enough to avoid breakage of the electrode rod.

Halogen dosed into a lamp as the only intentionally added tungsten transport means could keep clear the discharge vessel without undue transport of tungsten from the electrode rods, by cooperation with unintentionally, as a contaminant, added oxygen. In this event, however, other contaminants in the gas filling, on the electrodes and their rods, and on the discharge vessel, such as carbon, iron, phosphorus and hydrogen, may have a strong influence either
5 on the transport of tungsten towards the discharge vessel or towards the electrode.

By making the electrode rods to have rhenium in the second portion thereof, reactions of that portion with bromine and oxygen are hampered. By making the first portion of the electrode rods from tungsten it is avoided that a strong evaporation occurs, as
10 it would be the case in the event the first portion consists of rhenium. The temperature of the common boundary of the first and the second portions is chosen to be about the temperature at which both the rhenium vapor pressure at higher temperatures and the sum of the tungsten vapor pressure and the pressures of tungsten compounds at adjacent lower temperatures than the boundary temperature would be substantially higher.

15 A first tungsten rod may be welded, e.g. butt welded, to a second rhenium or rhenium alloy rod, e.g. by resistance welding or laser welding. In this event the second rod may be chosen to be slightly, e.g. 10 to 15 %, thicker, if so desired, in order to compensate for the lower heat conductivity of rhenium: $S_{Re} \approx 0.3 * S_w$.

The common boundary of the first and the second portions is at a
20 location having a temperature during operation of 1900 - 2300 K. This temperature may be chosen for a particular type of lamp in dependency of the gas filling and the quality of the manufacturing process, which could cause the lamp to contain more or less contaminants influencing the total vapor pressure of tungsten and tungsten compounds. For each type of lamp the optimum temperature of said common boundary can easily be determined in a small
25 series of test lamps by monitoring the luminous efficacy of the lamps during their life. Generally, it is favorable to have the boundary at a temperature in the range of 2100 - 2300 K.

In a favorable embodiment a common boundary region is formed by the first and the second portion over which during lamp operation the temperature lies between
30 2300 and 1900 K and in which boundary region the second portion is enclosed by a mantle substantially made of tungsten. This is realized e.g. by an electrode rod having a core made of rhenium or a rhenium alloy and a mantle made of tungsten or e.g. by an overlapping of the wrapped tungsten wire from the first portion with the rhenium containing portion. An electrode with this type of boundary allows a less accurate production of the boundary of the

first and the second portion, since, due to an overlap of the first and the second portion. Less accuracy is allowed since the position of the boundary is self-adjusting during operation of the lamp. Subsequently, such an electrode rod facilitates the processing of the lamp.

In a further favorable embodiment the electrode rod consists of three portions. A first portion of the electrode adjacent the electrode tip is made of tungsten, a second rhenium containing portion which during operation of the lamp extends over the temperature range of the electrode of 1400 - 2300 K, and a third portion in which the rhenium containing portion is replaced by another material e.g. tungsten, molybdenum or tantalum. The third portion may begin at a location where the electrode surface is hardly accessible by the gases of the filling of the lamp. The temperature at this location is lower than 1400 K during normal operation of the lamp. The third portion is secured to the current lead-through conductor. The electrode is cheaper and the material that extends into the pinch can be chosen independently.

The gas filling may, apart from bromides like sodium bromide, thallium bromide, indium bromide or other non rare earth metal bromides, contain metal iodides, such as sodium iodide and stannous iodide. Oxygen may have been introduced into the discharge vessel e.g. in admixture with rare gas, or as a compound e.g. as an oxyhalide or as tungsten oxide. Metal oxyhalides, particularly tungsten oxyhalides, such as WOI_2 , WO_2Br_2 and WOBr_2 , will be formed during operation of the lamp. Not operated, the lamp may have a deposit of tungsten oxide on the wall of the discharge vessel.

The electrodes may be the tips of the electrode rods, i.e. the tips of the first electrode rod portions, or separate bodies secured to the electrode rods, or fused end portions of the electrode rods. A wire wrapping, generally of tungsten wire, may be present near the electrodes, e.g. to adjust their temperature.

The discharge vessel may consist of ceramic, e.g. of mono- or polycrystalline alumina, or of high silica glass, e.g. of quartz glass. The discharge vessel may be surrounded by an outer envelope, if so desired. An outer envelope may be filled with inert gas or be evacuated. The lamp may be socketed, e.g. at one or at both of its ends.

The lamp of the invention may e.g. be used with fiber optics, as a projection lamp etc., and particularly in those applications in which an unobstructed light ray path from the discharge arc to outside the discharge vessel or in which long life times and a good luminous maintenance are required.

An embodiment of the lamp of the invention is shown in the drawing in which:

Fig. 1 is the lamp in side elevation;

Fig. 2A-C are examples of various electrode rods in cross-sectional view;

Fig. 3 is a graph showing vapor pressures.

The high-pressure metal halide lamp of Fig. 1 has a sealed light-transmittent discharge vessel 1, in the Fig. of quartz glass, but alternatively of mono- or polycrystalline ceramic, which has opposite seals 2 and which envelopes a discharge space 3. The lamp shown in Fig. 1 is an AC-lamp, but DC-lamps fall within the scope of this invention as well. The discharge space has a gas filling comprising rare gas and metal halides. Tungsten electrodes 5 are oppositely disposed in the discharge space 3. Current leadthrough conductors 6 are located in a respective seal 2 of the discharge vessel 1 and issue from the discharge vessel. In the Fig. the current lead-through conductors are each composed of a metal foil 6a, e.g. of molybdenum, which is fully located inside a respective seal, and of a metal rod 6b, e.g. of molybdenum, which extends to outside the discharge vessel 1. Electrode rods 7 are connected to a respective one of said leadthrough conductors 6, in the Fig. by welding them to the metal foils 6a, enter the discharge space 3 and carry a respective one of said electrodes 5.

The gas filling contains metal oxyhalides and is substantially devoid of rare earth metal compounds. The electrode rods 7 have a first portion 71 of tungsten adjacent the electrode 5 which merges into a second portion 72 at a location 73 having a temperature in the range of 1900 - 2300 K, particularly 2100 - 2300 K, in the Fig. 2100 K, during operation. In the Fig. the second portions 72 of the electrode rods 7 consists of rhenium and are thicker, have a diameter of 1 mm, than the first portions 71, which have a diameter of 0.8 mm. The electrodes 5 in the Figure are free end portions of the first electrode rod portions 71.

In Fig. 1 the electrode rods 7 have at the first portion 71 a wrapping 74 of tungsten wire adjacent the electrodes 5, to adjust the temperature of the electrodes.

The lamp of Fig. 1 consumes a power of 200 W. The lamp, having a volume of 0.7 cm³ and an electrode distance of 3 mm, was filled with 0.87 mg NaI, 0.45 mg SnI₂, 0.76 mg NaBr, 0.21 mg TlBr, 0.17 mg HgI₂, 2666 Pa O₂, 44 mg Hg and 10 000 Pa Ar. When the lamp is switched on, the oxygen reacts to form oxyhalides.

After 1600 hrs of operation, during which the common boundaries of the first and the second electrode rod portions were at a temperature of about 2100 K, the discharge vessel was still fully clear the lamp had not reached the end of its life, yet.

This is in contrast to a test lamp in which one of the electrode rods was of the design shown in Fig. 1 and the other consisted of tungsten. The electrode distance was 5 mm. The lamp had a filling of 0.89 mg SnI_2 , 0.14 mg HgI_2 , 0.13 mg WO_3 , 39 mg Hg and 10 000 Pa Ar. After 125 hrs of operation at a power of 200 W, the tungsten electrode rod broke down, thereby causing the end of the life of the lamp, whereas no signs of change of the other electrode rod were seen. The lamp vessel was still clean. When the lamp was first operated, the tungsten oxide reacted with halogen to form oxyhalide.

In Fig. 2a the electrode rod 7 has a first portion 71 and a wire wrapping 74 of tungsten and a second portion 72 of rhenium/tungsten alloy up to the location 73.

In Fig. 2b the electrode rod 7 has a first portion 71 and a wire wrapping 74 of tungsten, a second portion made of rhenium, which portions have a common boundary region at location 73. Location 73 extends over a distance X over the electrode rod 7. Over the distance X the temperature lies between 2300 and 1900 K during normal operation of the lamp. The location 73 is formed by the boundary region between a core 76 made of rhenium which is enclosed by a mantle 77 made of tungsten.

In Fig. 2c the electrode rod 7 has a first portion 71 and a wire wrapping 74 of tungsten, a second portion 72 made of a rhenium/tungsten alloy from locations 73 to 81 and a third portion 80 made of molybdenum.

In Fig. 3 the curve W designates the sum of the pressure of tungsten vapor and of the pressures of tungsten compounds in a lamp in dependency of the temperature, whereas the curve Re represents the rhenium vapor pressure at different temperatures.

It is seen, that the rhenium vapor pressure increases with an increasing temperature. Thus, rhenium evaporates faster the higher its temperature.

It is also seen, that the sum of the tungsten pressures is highest at about 1500 K and lowest at about 2250 K. This means that a tungsten surface of 1500 K will loose tungsten by evaporation and by chemical reactions giving volatile products, which will be transported and be deposited at a surface of about 2250 K, or higher due to faster decomposition reactions at higher temperatures, 2300 - 2500 K. These processes are not desired, because they would transport tungsten from a tungsten electrode rod towards the electrode, thereby causing the rod to become thinner and to break.

It is also seen, however, that the tungsten pressures at about 1150 K, that is at the wall of the discharge vessel, are relatively high. Tungsten will be transported, too, from locations of this temperature to locations of about 2200 K or higher. This transport is aimed at, because it keeps the wall clear.

5 In the Fig. the two curves intersect at about 2000 K. In a lamp in which the impurities influencing the volatility of tungsten compounds cause the W curve to be as shown, the temperature of the point of intersection of the curves is the proper temperature of the common boundary at the location 73 of the first 71 and the second electrode rod portions 72. If in the lamp the temperature of said common boundary would be higher than the one
10 shown, the highest rhenium temperature in the lamp would be higher and there would be a higher rhenium evaporation. If in the same lamp the temperature of the common boundary would be lower, the highest rhenium temperature would be lower and as a consequence the rhenium vapor pressure would be lower, but the tungsten pressures at the boundary would be higher and consequently transport of tungsten from that place to places of higher temperature
15 where the W curve has a minimum would occur. At other impurity levels in the lamp the W curve shifts to the right and the two curves intersect at a higher temperature. In a lamp without substantial impurities the curves will intersect at about 1900 K.

CLAIMS:

1. A high-pressure metal halide lamp comprising:
a sealed light-transmittent discharge vessel (1) having opposite seals (2)
and enveloping a discharge space (3) which has a gas filling comprising rare gas and metal
halides;
5 tungsten electrodes (5) oppositely disposed in the discharge space (3);
current lead-through conductors (6) located in a respective seal (2) of the
discharge vessel (1) and issuing from the discharge vessel;
electrode rods (7) secured to a respective one of said lead-through
conductors (6) entering the discharge space (3) and carrying a respective one of said
10 electrodes (5),
characterized in that the gas filling contains metal oxyhalides and is
substantially devoid of rare earth metal compounds, the electrode rods (7) have a first portion
(71) of tungsten adjacent the electrode (5) which merges into a second portion (72) at a
location (73) having a temperature in the range of 1900 - 2300 K during operation, the
15 second portion (72) is made of at least 25 % by weight of rhenium, rest tungsten and being
secured to a respective current lead-through conductor (6).
2. A high-pressure metal halide lamp as claimed in Claim 1, characterized
in that the location (73) has a temperature in the range of 2100 - 2300 K during operation.
3. A high-pressure metal halide lamp as claimed in Claim 1 or 2,
20 characterized in that the second portions (72) of the electrode rods (7) consists of rhenium.
4. A high-pressure metal halide lamp as claimed in Claim 3, characterized
in that the second portions (72) of the electrode rods (7) are thicker than the first portions
(71).
- 5 A high-pressure metal halide lamp as claimed in Claim 1, characterized
25 in that the location (73) is formed by a boundary region over which during operation the
temperature lies between 2300 and 1900 K and at which boundary region the second portion
(72) is enclosed by a mantle (77) substantially made of tungsten.
- 6 A high-pressure metal halide lamp as claimed in Claim 1, characterized
in that the electrode rods (7) comprise first (71), second (72) and third portions (80) in which

the second portions merges into the third portions at second locations (81) having a temperature lower than about 1400 K during operation of the lamp and which third portions being secured to respective current lead-through conductors (6).

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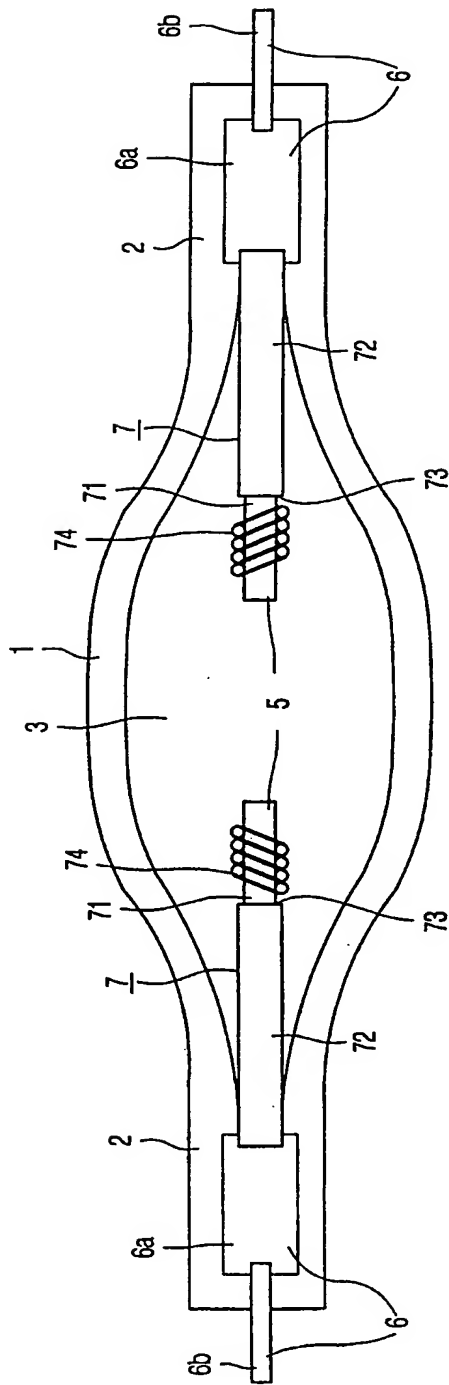


FIG.1

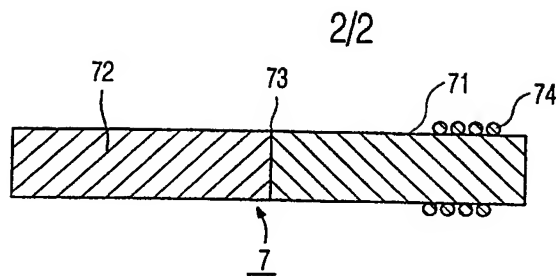


FIG. 2A

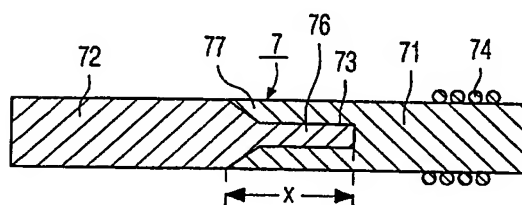


FIG. 2B

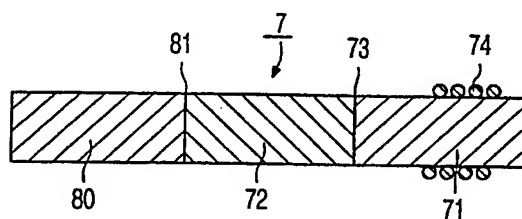


FIG. 2C

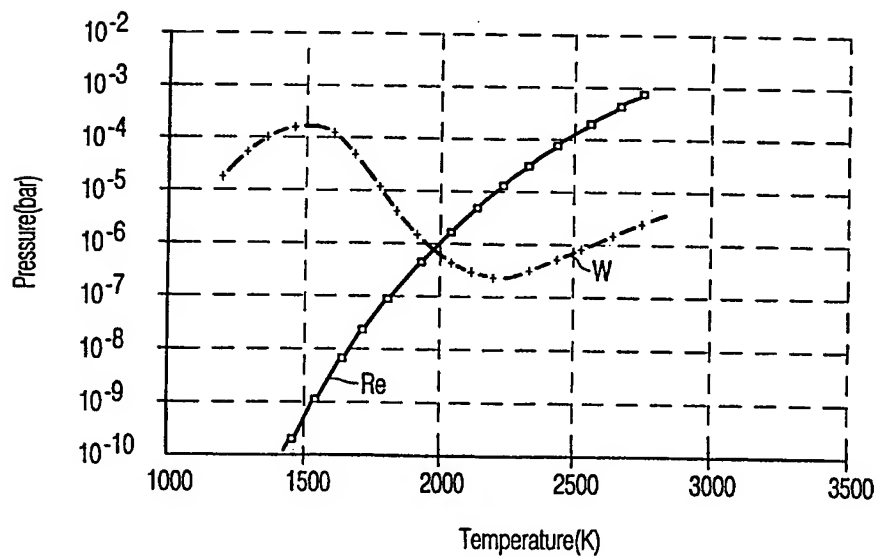


FIG. 3

INTERNATIONAL SEARCH REPORT

International application No.

PCT/IB 98/00195

A. CLASSIFICATION OF SUBJECT MATTER		
IPC6: H01J 61/073, H01J 61/36 According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED		
Minimum documentation searched (classification system followed by classification symbols)		
IPC6: H01J		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
SE,DK,FI,NO classes as above		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)		
WPI		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5510675 A (AXEL BUNK ET AL), 23 April 1996 (23.04.96), page 3, line 44 - line 63, figure 3 --	1-6
A	US 3988629 A (JOHN E. WHITE ET AL), 26 October 1976 (26.10.76), page 2, line 28 - line 36, figure 1 --	1-6
A	EP 0581354 A1 (PHILIPS ELECTRONICS N.V.), 2 February 1994 (02.02.94), abstract, see the figure --	1-6
A	EP 0649164 A2 (HAMAMATSU PHOTONICS K.K.), 19 April 1995 (19.04.95), abstract, see the figure --	1-6
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input checked="" type="checkbox"/> See patent family annex.		
* Special categories of cited documents "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search		Date of mailing of the international search report
24 July 1998		27 -07- 1998
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/IB 98/00195

Patent document cited in search report			Publication date	Patent family member(s)		Publication date
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